

Date: Monday, 25/05/2009 12:48:32 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BUSHING
Job Number :	48186		
Estimate Number :	10310		
P.O. Number :		Part Number :	D26175
This Issue :	25/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2617 REV D2
First Issue :	/ /	Project Number :	N/A
Previous Run :	46607	Drawing Revision :	D2
	Type :	Material :	
	MACHINED PARTS	Due Date :	01/06/2009
Written By :		Qty:	100
Checked & Approved By :	<u>JULIA 09.05.25</u>	Um:	Each
Comment :	Est H 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 RD Tube .500 x.058W
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Comment: Qty.: 0.0205 f(s)/Unit Total : 2.0475 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch 1111757

09.05.25

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

09.05.26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/05/26

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 48186

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



101.

Comment: INSPECT ALODINE

JP 09-05-26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



107C

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 39

9/5/26

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27 *JP*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

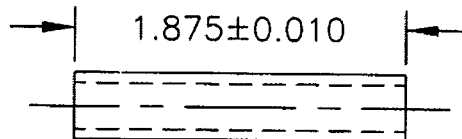
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

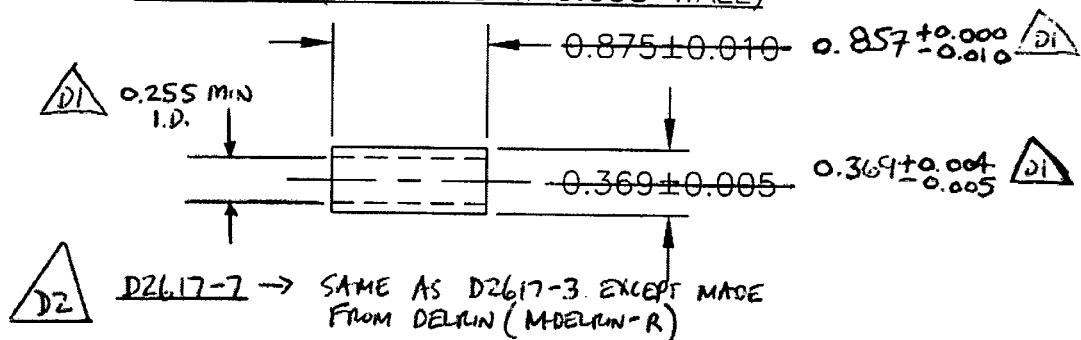
DART

DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
D2	04.04.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	CP 04.07.12 CORRECT TOLERANCE (NCR 774)

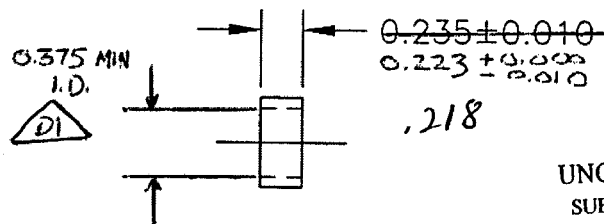
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)


RELEASED
 01.07.05 #

 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 48181
NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4) OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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